

# Work Order ID 67005

Thursday, March 03, 2011 10:47:19 AM



Page 1

Item ID: D3659-1

Accept



Setup Start



Revision ID:

Stop



Item Name: CUFF

Start Date: 3/3/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 3/7/2011

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3659

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 7.300" long

W515

6 0

110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per folio FA 707 & DWG D3659,  
FOLIO REV: B  
DWG REV: B  
2-Deburr as required

W515

6 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W515

6 0

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Page 2

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Start Date: 3/3/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 3/7/2011

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

K.A 11/05/05

6

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6

0

11/05/06

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

S 11/05/06

(46)

Quality Control

**Work Order ID 67005**

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Revision ID:

Stop



Item Name: CUFF

Start Date: 3/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 477

0.00



Packaging

Memo

0.00

Packaging

11/5/11 SP 60

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 SP11-05-9  
(4)

# Picklist Print

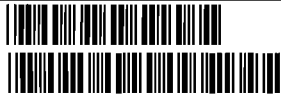
Thursday, March 03, 2011 10:47:26 AM

Page 1

Work Order ID: 67005

Parent Item: D3659-1

Parent Item Name: CUFF



Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM  
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6009-129  Crosstube Material	D6006-129	Manufactured	No			100	Each	8.0000	.619 0.056	0.353684		11/5/13	

## Location

LG

38342

53594

## Loc Qty

8

2

6

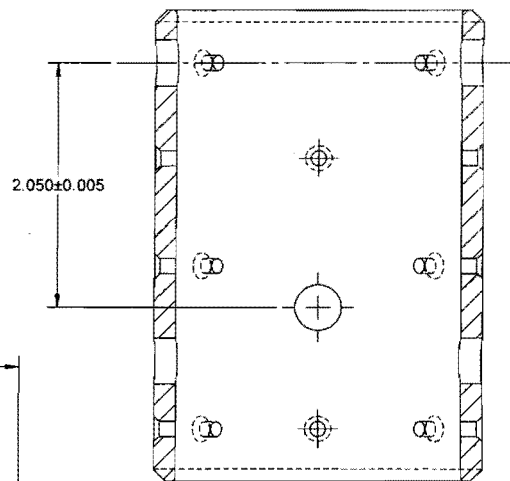
## Loc Code

7 B 29112

3.7 AT

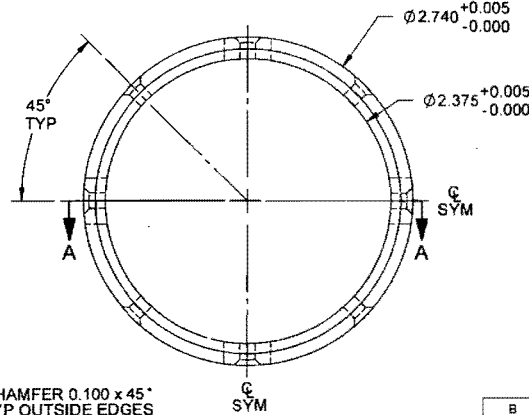
~~D6008-102~~  
~~B 50892~~





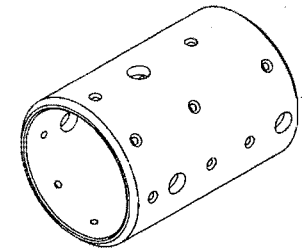
SECTION A-A

R0.032 TYP  
INSIDE EDGES



CHAMFER 0.100 x 45°  
TYP OUTSIDE EDGES

D3659-1 CUFF



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67005

2011-03-3

100-04-09 MP

DRILL #30 (Ø0.128 REF)  
C'SINK Ø0.230x100°  
TYP 22 PLACES



Ø0.386<sup>+0.005</sup>  
-0.000

HOLE TO BE ALIGNED  
WITHIN ±0.001 OF HOLE  
ON OTHER SIDE OF CUFF,  
TYP 6 PLACES



NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)  
(CAN MAKE FROM D6005, D6006, D6008, D6009, D6011, OR D6019)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.56 lbs

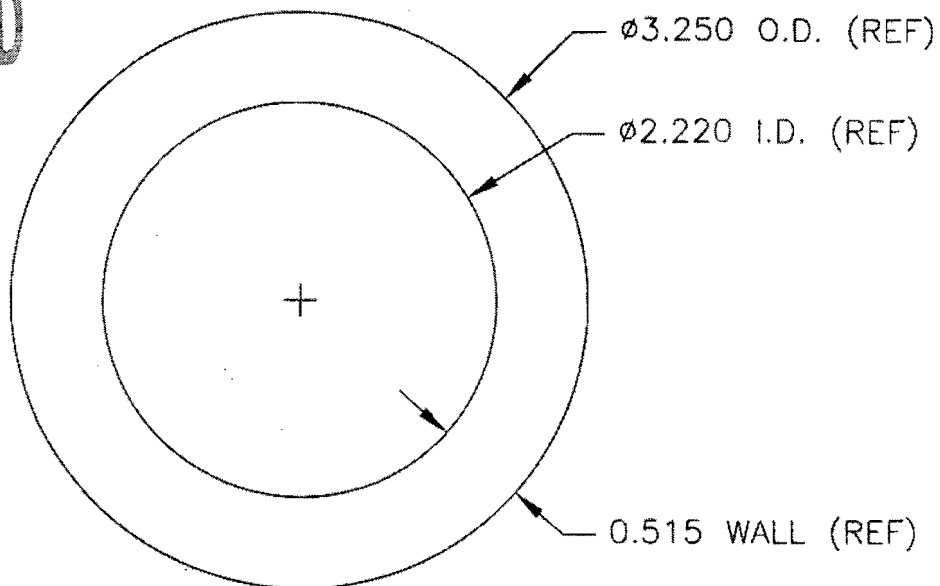
B	ADD Ø0.128 & Ø0.386 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV	DESCRIPTION	BY	DATE
DESIGN	P		
DRAWN	P		
CHECKED	H		
MFG. APPR.	E		
APPROVED	MP		
DE APPR.	H		
DATE	08.03.03		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3659</b> TITLE <b>CUFF</b> REV. B SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPLICIT CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D6006	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.17	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
00.11.74 *A*



### NOTES

- 1) D6006-XXX CROSSTUBE  
LENGTH

WHERE XXX IS LENGTH IN INCHES  
EG. 129" LONG TUBE: D6006-129

*CL 11/05/05*  
*WID: 67005*

- 2) MATERIAL: 3.250 OD x 0.515 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.  
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi  
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:  
O.D.:  $\pm 0.008$  MEAN ( $\pm 0.016$  INCLUDING OVALITY)  
WALL:  $\pm 0.020$  MEAN ( $\pm 0.052$  INCLUDING ECCENTRICITY)  
LENGTH: XXX  $+0.188/-0.000$   
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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